

Date: Thursday, 05/02/2009 3:46:21 PM  
User: Julie Dawson

## Process Sheet

|                           |   |   |                                      |
|---------------------------|---|---|--------------------------------------|
| Customer                  | CU-DAR001 Dart Helicopters Services   | Drawing Name  | CROSSBOLT SPACER                     |
| Job Number                | 45555   |   |                                      |
| Estimate Number           | 10329   |   |                                      |
| P.O. Number               | :   | Part Number   | : D2743                              |
| This Issue                | : 05/02/2009  | S.O. No. :  | D2743 REV B                          |
| Prsht Rev.                | : NC  | Project Number  | : N/A                                |
| First Issue               | : / /   | Drawing Revision  | : B                                  |
| Previous Run              | : 44891   | Material  | :                                    |
| Written By                | :   | Due Date  | : 28/02/2009                         |
| Checked & Approved By     | : <u>JUD 09.02.09</u>   | Qty:  | 300                                  |
| Comment                   | : Est E 05.04.13 Rerformat; removed tumble and deburr step KJ/J<br>LM   |   |                                      |
| <b>Additional Product</b> |   |   |                                      |
| Job Number:               |    |   |                                      |
| Seq. #:                   | Machine Or Operation:   | Description :   |                                      |
| 1.0                       | M6061T6T0625W065  | 6061-T6 RD Tube .625 x.065W<br>              |                                      |
| Comment:                  | Qty.: 0.2800 f(s)/Unit Total : 84.0105 f(s)<br>Material: 6061-T6 (WW-T-700/6)<br>Ø0.625 " x 0.065" wall<br>(M6061T6T0.625W.065) Batch: <u>M102450 - 4ft M110778 - 80.0105ft</u> | 09/02/09  | *Material not removed from computer. |
| 2.0                       | HARDINGE  | HARDINGE CNC LATHE SMALL<br>               |                                      |
| Comment:                  | 1-TURN AS PER FOLIO FA202 & DWG D2743<br><br>FOLIO REV: <u>A</u><br>DWG REV: <u>B</u>   | 09/02/09  | <u>300 pcs</u>                       |
| 3.0                       | QC2   | INSPECT PARTS AS THEY COME OFF MACHINE<br> |                                      |
| Comment:                  | INSPECT PARTS AS THEY COME OFF MACHINE  | 09/02/09  | <u>300 pcs</u>                       |
| 4.0                       | QC8   | SECOND CHECK<br>                           |                                      |
| Comment:                  | SECOND CHECK  | 09/02/09  | <u>300 pcs</u>                       |
| 5.0                       | PACKAGING 1   | PACKAGING RESOURCE #1<br>                  |                                      |
| Comment:                  | PACKAGING RESOURCE #1<br>Identify and Stock<br>Location: <u>Barb</u>  | 09/02/09  | <u>Loc</u>                           |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CROSSBOLT SPACER

Job Number: 45555

Part Number: D2743

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



09/02/10 JF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-02-09

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

|                                |              |             |
|--------------------------------|--------------|-------------|
| DART AEROSPACE LTD             | Work Order:  | 4555        |
| Description: Cross Bolt Spacer | Part Number: | D2743       |
| Inspection Dwg: D2743          | Rev: B       | Page 1 of 1 |

# FIRST ARTICLE INSPECTION CHECKLIST

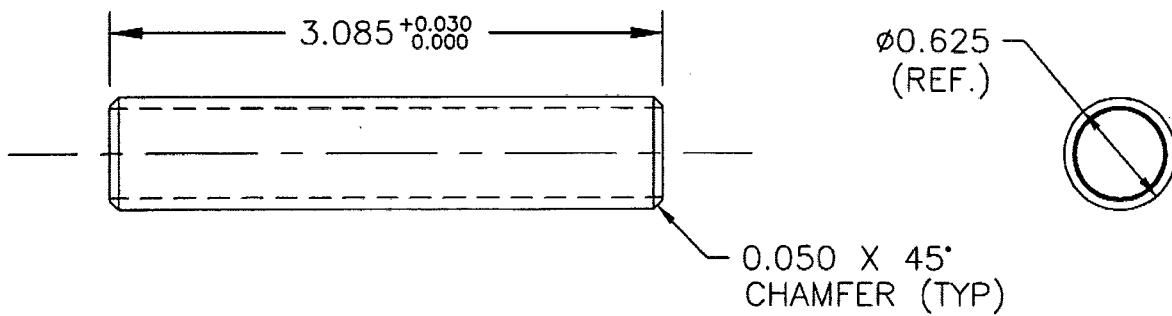
## X First Article      Prototype

|              |                 |             |                 |                     |     |
|--------------|-----------------|-------------|-----------------|---------------------|-----|
| Measured by: | <u>C</u>        | Audited by: | <u>SR</u>       | Prototype Approval: | N/A |
| Date:        | <u>09/02/08</u> | Date:       | <u>09/02/09</u> | Date:               | N/A |

| Rev | Date     | Change   | Revised by | Approved           |
|-----|----------|--|------------|--------------------|
| A   | 04.04.20 | New Issue  | KJ/RF      |                    |
| B   | 06.11.20 | Tolerance $+-0.010 \times 45^\circ$ was $0.48 \times 45^\circ$ | KJ/JLM     | <i>[Signature]</i> |

**DART**

|                       |                       |  |
|-----------------------|-----------------------|--|
| DESIGN<br><i>111</i>  | DRAWN BY<br><i>CP</i> | DART AEROSPACE USA, INC.<br>BELLEVUE, WA |
| CHECKED<br><i>111</i> | APPROVED<br><i>KE</i> | DRAWING NO.<br>D2743                     |
|                       |                       | REV. B<br>SHEET 1 OF 1                   |
| DATE<br>98.12.08      |                       | TITLE<br>CROSS BOLT SPACER               |
|                       |                       | SCALE<br>1:1                             |
| A                     | 98.04.16              | NEW ISSUE                                |
| B                     | 98.12.08              | 3.085 WAS 3.060                          |

**RELEASED**  
*98.12.16 DS*

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 45555

MATERIAL: 6061-T6 (WW-T-700/6) 0.625 DIA. X 0.065 WALL  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED